

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 16.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029746**Date Inspected:** 22-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** XKT/NESCO, Vallejo, Ca.**Location:** Vallejo, CA**CWI Name:** Wayne Van Dewark**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Crossbeam Retro-Fit Angle**Summary of Items Observed:**

Summary of Items Observed: Caltrans Quality Assurance Inspector Simion Ramirez (QA Inspector) arrived at XKT facility, in response to an Inspection Request (Caltrans form TL-38). QA Inspector met with Quality Control Contact (QCC) noted above to witness fabrication of Saddle and Crossbeam Retrofit Angle. Production work was selected randomly by QA Inspector for QA Visual Testing (VT). Inspections performed were in accordance (IAW) with Section 55 Steel Structures of the Standard Specifications and the project Special Provisions.

Crossbeam Retrofit Angle:

XKT personnel fit-up and started welding the corner joint for piece mark M1. Welding procedure TC-U4b was available for the welder to reference. QC Inspector verified fit-up and pre-heat. QC Inspector verified electrical welding parameters at the start of shift and randomly until the end of shift. Several weld passes were installed on the groove side of joint. Weld passes were cleaned by chipping and wire brush. The welded joint was back gouged to sound material by carbon air-arc. The welding of piece M1 remains in process.

- A square straight edge was utilized to check fit-up and alignment of assembled components.
- Preheat was performed by rosebud touch and verified with temperature stick.
- Welding was performed by approved welder (Alberto Garcia).
- Weld Procedure TC-U4b is for complete joint penetration (CJP).

Fabrication and welding remains in progress.

Summary of Conversations:

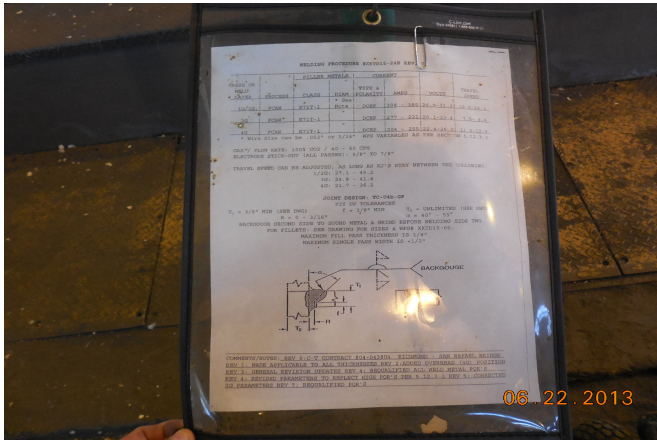
Only general conversation related to the comments noted above.

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WPS available at weld station.

Corner CJP welded with FCAW.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Ramirez, Simion

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer